

**NOTES:**

1) MATERIALS:

RESIN: EPOCAST 50-A/9816,  
OR DERAKANE 470-36/411/510A40

FOAM: A500 CORE CELL,  
OR DIVINYCELL,  
OR AIREX,  
0.38 THICK (3/8 FOAM)

FIBRE: 9.7 oz 7781 WEAVE "S" GLASS (9 oz SATIN)  
5 oz PLAIN WEAVE KEVLAR (5 oz KEVLAR)

2) FINISH: INSIDE = PRIME PER DART QSI 005 4.2  
OUTSIDE = WHITE GELCOAT #GEL 944W005

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: NONE

7) WEIGHT: N/A

8) LAMINATE PER DART QSI 006.  
LAMINATION SCHEDULE PER THIS DRAWING.

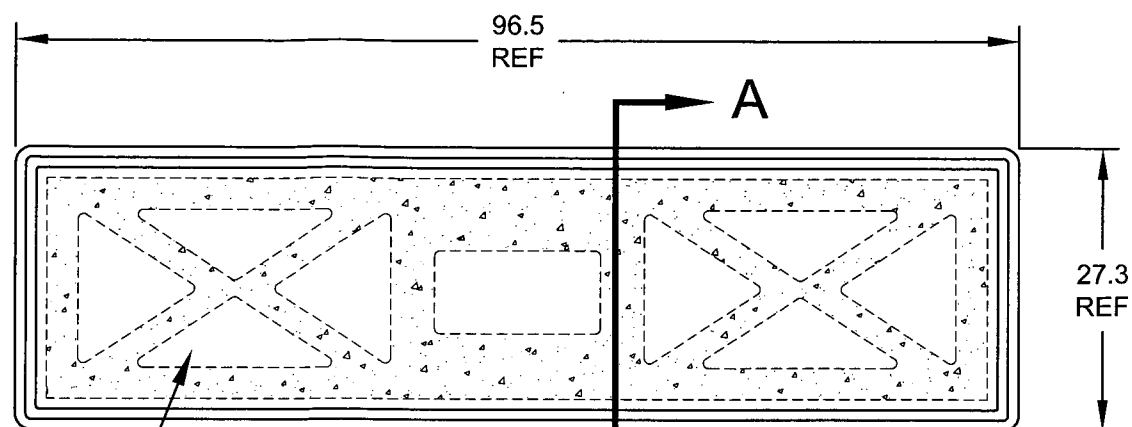
9) PEEL PLY ALL SURFACES.

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2010-10-28  
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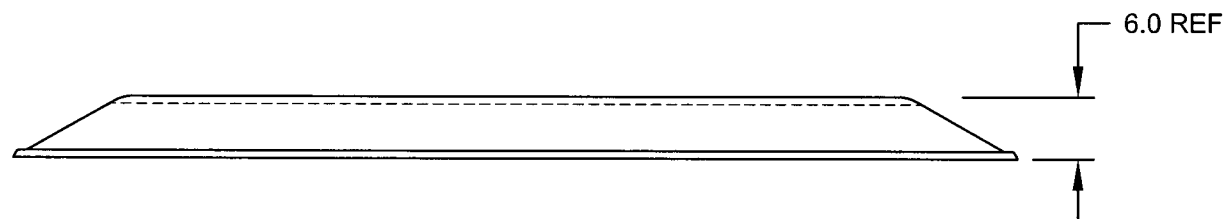
G	REFORMAT DRAWING TO CURRENT STANDARDS; D2202-101 WAS D2202-1 (ZN C5-2, A4-2); ADD 77.5 & 22.0 DIM. (ZN D4-3, C6-3); D2202-103 WAS D2202-5 (ZN C5-3, A4-3); ADD 2.00 MAX (ZN D3-4); INCORPORATED DEO 9217 & ADD D2202-5/-6 ON SHEET 5 PER PAR 09-034	RF	09.10.06
F	CHANGE LAYUP, DOUBLER, NOW DRILLED	CP	01.03.14
E	ADDED SECTIONS WITH LIP DIMS	KE	99.11.11
D	MOVED DOUBLERS, REMOVED HOLES	KE	98.11.09
C	REVISED DOUBLER/HOLES LOCATIONS	KE	97.07.04
B	ADD DOUBLERS AND HOLES	-	93.10.27
A	NEW ISSUE	-	93.10.27
REV.	DESCRIPTION	BY	DATE
DESIGN	KE	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	97	DRAWING NO.	REV. G
MFG. APPR.	JM	D2202	SHEET 1 OF 5
APPROVED	140	TITLE	SCALE
DE APPR.	HA	UTILITY POD LID AND BASE	NTS
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SEE  
DETAIL B  
A6-2

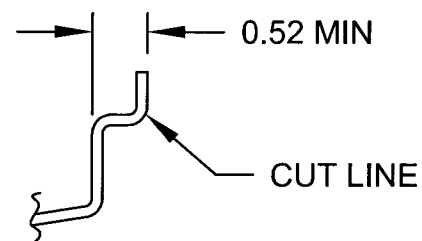
**SECTION A-A** C3-2



**G**  
D2202-101 FOAM CORE,  
MAKE FROM 3/8" FOAM, ROUTER PER DT8024



**D2202-1 LID**  
(MOLD DT8002)



**DETAIL B** D6-2  
**SCALE 10X**

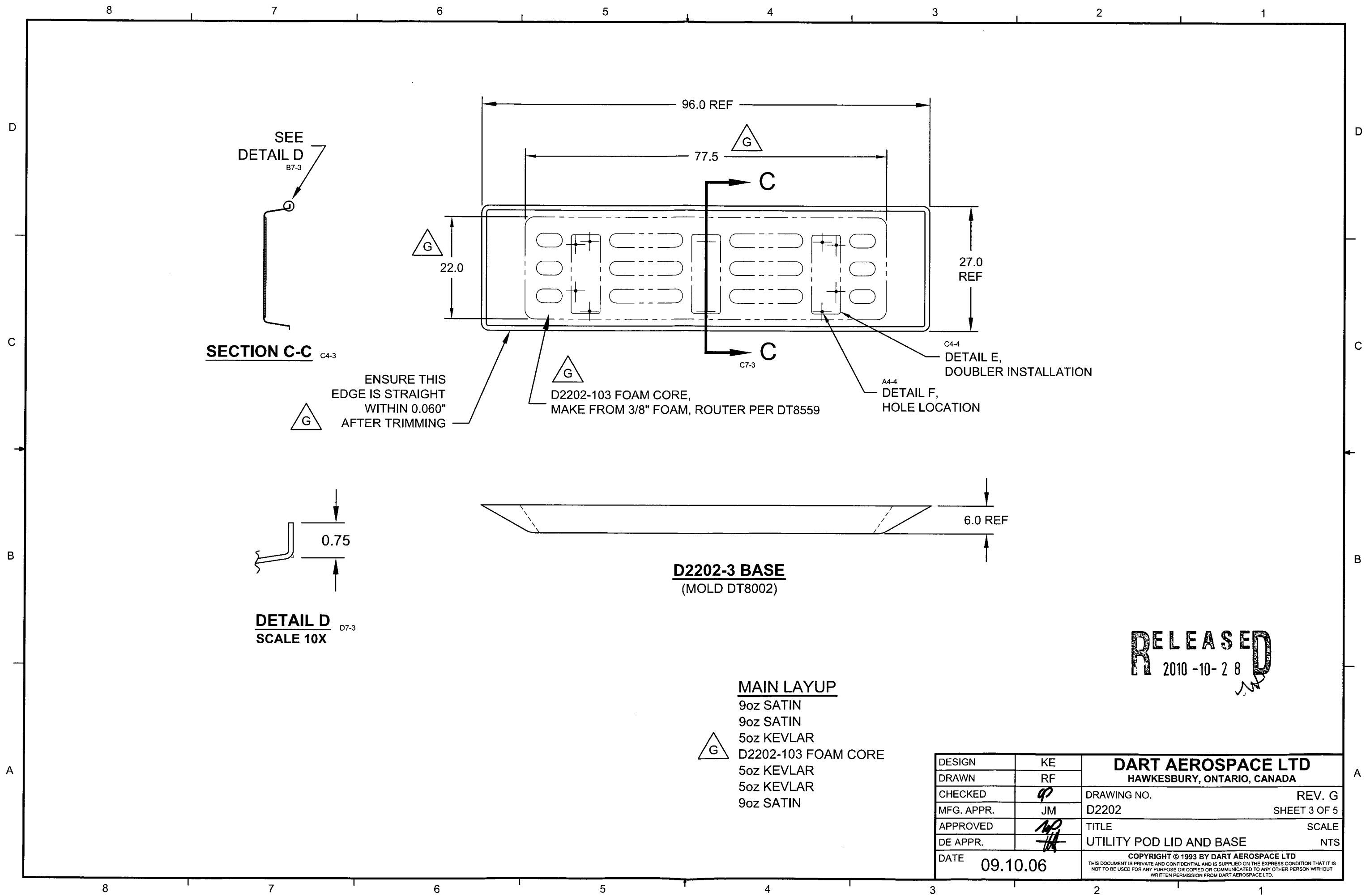
**MAIN LAYUP**

9oz SATIN  
9oz SATIN  
5oz KEVLAR  
D2202-101 FOAM CORE  
5oz KEVLAR  
9oz SATIN



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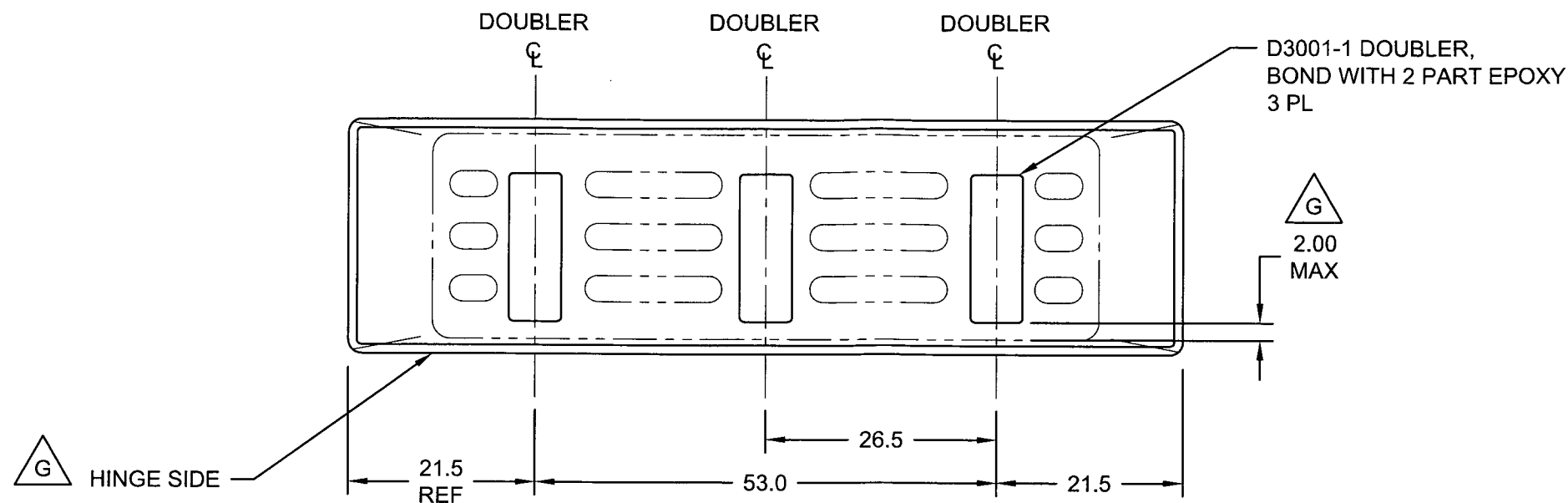
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**MAIN LAYUP**

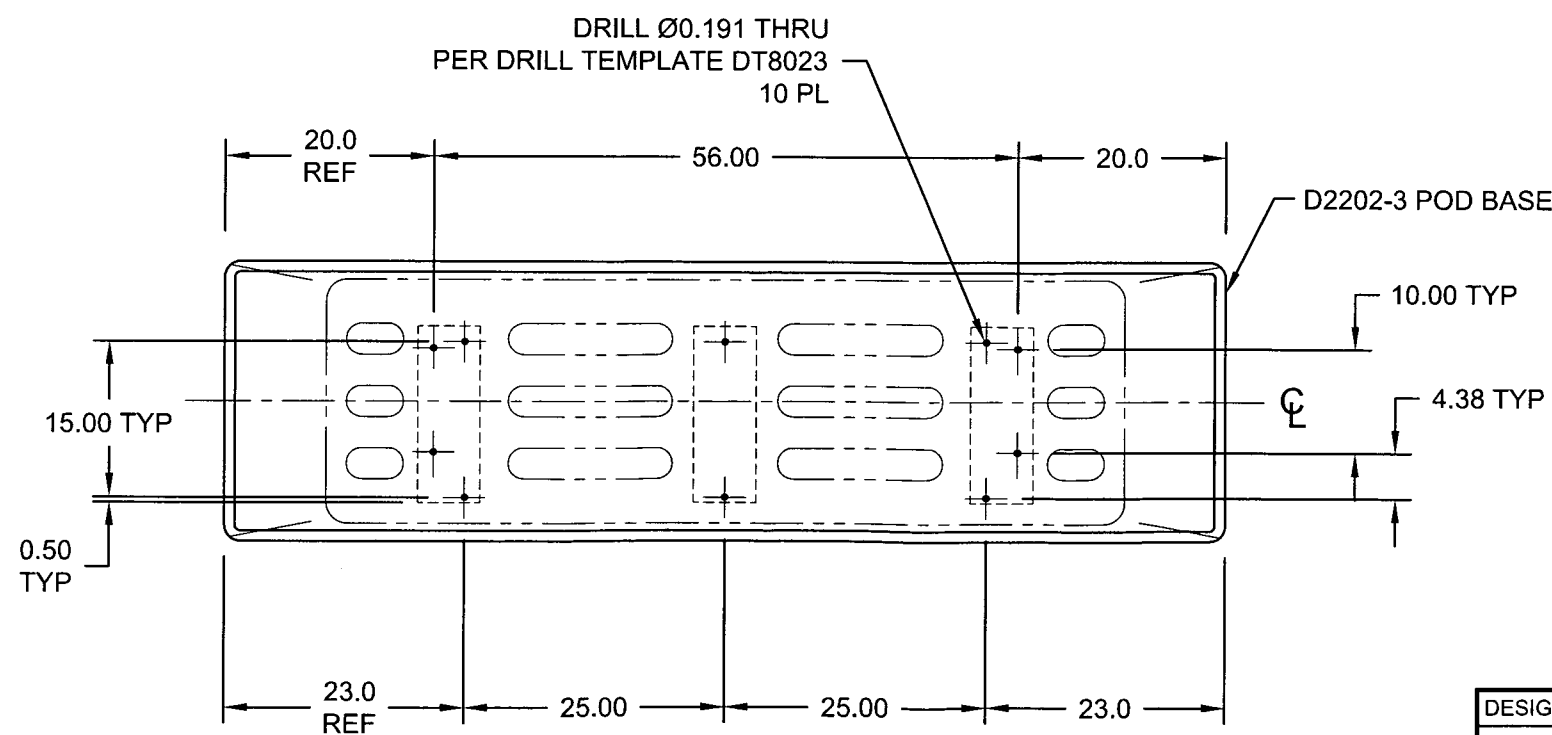
- 9oz SATIN
- 9oz SATIN
- 5oz KEVLAR
- D2202-103 FOAM CORE
- 5oz KEVLAR
- 5oz KEVLAR
- 9oz SATIN



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**DETAIL E: INSTALLATION OF D3001-1 DOUBLERS** C3-3



**DETAIL F: HOLE DRILLING  
(AFTER DOUBLER INSTALLATION)** C3-3

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2010-10-28

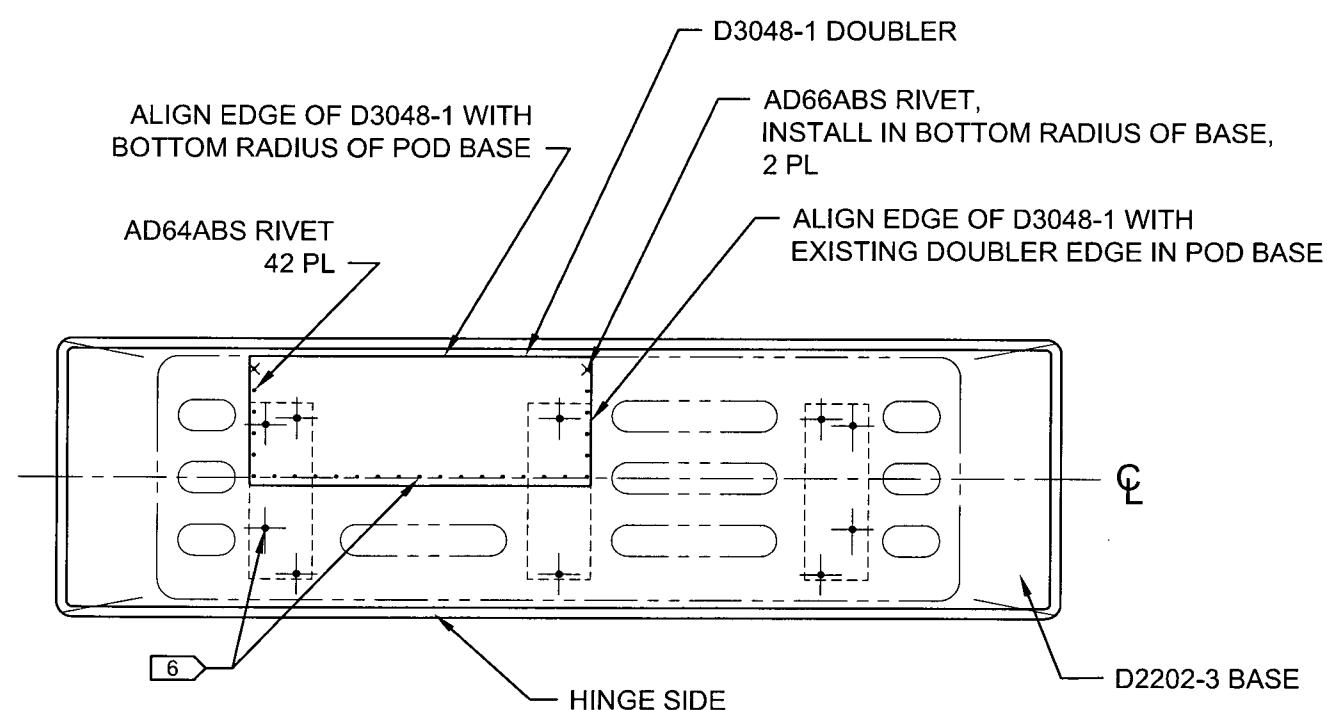
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# **NOTES : TO MAKE A D2202-5/-6 BASE (FOR D350-602-013/-014) FROM A D2202-3 BASE**

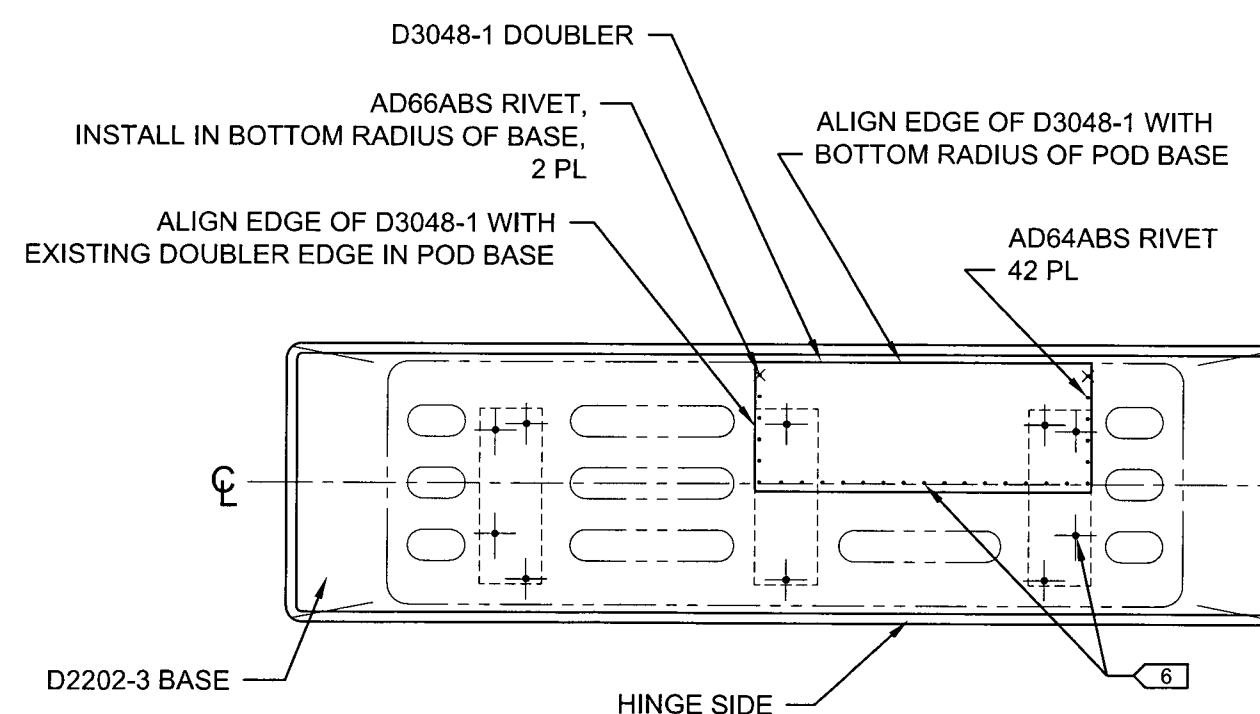
- 1) REMOVE FOAM IN AREA OF POD BASE WHERE D3048-1 DOUBLER WILL BE INSTALLED
- 2) FILL GAPS WITH 9oz SATIN AND RESIN PER DWG (APPROX. 3-4 LAYERS)
- 3) 2 LAYERS OF 9oz SATIN
- 4) BOND D3048-1 DOUBLER IN ORIENTATION SHOWN AND LET CURE
- 5) TRANSFER Ø0.125 HOLES FROM D3048-1 TO POD BASE. INSTALL DOUBLER WITH AD64ABS RIVETS (42) AND AD66ABS (2)
- 6) TRANSFER Ø0.191 HOLES FROM POD BASE TO D3048-1. SEAL HOLES WITH CYANOACRYLATE GLUE
- 7) TOUCH UP AFFECTED AREA WITH GREY PRIMER PER DWG
- 8) FILL CENTER OF THE AD RIVETS WITH RTV 732 TO SEAL

## **PART LIST:**

QTY -5	QTY -6	PART NUMBER	DESCRIPTION
X		D2202-5	POD BASE
	X	D2202-6	POD BASE
1	1	D2202-3	BASE
1	1	D3048-1	DOUBLER
42	42	AD64ABS	RIVET
2	2	AD66ABS	RIVET
A/R	A/R	RTV	SEALANT



**D2202-5 BASE: D3048-1 DOUBLER INSTALLATION**  
(MAKE FROM D2202-3 BASE)



**D2202-6 BASE: D3048-1 DOUBLER INSTALLATION**  
(MAKE FROM D2202-3 BASE)

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DE APPR.	JP	UTILITY POD LID AND BASE	NTS
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